

Work Order ID 60296

July 1, 2010 12:44:42 PM



Page 1

Item ID: D2666-1

Accept



Setup Start



Revision ID:

Stop



Item Name: Saddle, LH Fwd Aft In 206

Start Date: 02/07/2010 Start Qty: 4.00



Cust Item ID:

Required Date: 29/07/2010 Req'd Qty: 4.00



Customer:

Reference:

10-07-01

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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Draw Nbr

Revision Nbr

D2666

Rev D

100

0.00



HAAS CNC VERTICAL MACHINING #1

HAAS 1

Memo

0.00

HAAS CNC vertical machine #1

Program batch number. ☐ 1- Inspect part number and batch number are programmed correctly. ☐ 2- Machine Step No 1 of Folio and visually inspect as per attached Dimension Sheet ☐ 3- Machine Step No 2 of Folio and visually inspect as per attached Dimension Sheet

DT 10/09/20

4 *0*

110

0.00



CONVENTIONAL MILLING MACHINE

Mill Conv

Memo

0.00

Conventional Milling Machine

Machine Keyway and inspect per attached dimension sheet

DT 10/09/23

4 *0*

120

0.00



QC2- Inspect parts off machine FAI/FAIB

QC

Memo

0.00

Quality Control






DT 10/09/20



4 *0*




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Item ID:	D2666-1	Accept		Setup	Start	
Revision ID:						
Item Name:	Saddle, LH Fwd Aft In 206				Stop	
Start Date:	02/07/2010	Start Qty:	4.00		Cust Item ID:	
Required Date:	29/07/2010	Req'd Qty:	4.00		Customer:	
Reference:						

Approvals:	Process Plan:	Date:	Tooling:	Date:	Run	Start	
	QC:	Date:	SPC (Y/N):	Date:		Stop	

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
130  QC Quality Control	QC8- Inspect parts - second check Memo	0.00 0.00		SB 10/09/23		4	8		
140  HandFinish Hand Finishing	Chemical Conversion Coat per QSI005 4.1 Memo	0.00 0.00		BR 10-9-24		4	φ.		
150  Powdercoat Powder Coating	White Gloss(Ref:4.3.5.1) per QSI005 4.3-Alum M115291 Memo START TIME: 7:45 300° FINISH TIME: 8:15	0.00 0.00		BR 10-9-27.		④	φ.		

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Item ID: D2666-1

Accept

Setup Start

Revision ID:

Stop

Item Name: Saddle, LH Fwd Aft In 206

Start Date: 02/07/2010 Start Qty: 4.00

Cust Item ID:

Required Date: 29/07/2010 Req'd Qty: 4.00

Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

160

QC3- Inspect Part Finish

0.00

= 7/1 10/09/27

xcl

p



QC

Memo

0.00

Quality Control

170

Identify as per dwg & Stock Location: 426

0.00



Packaging

Memo

0.00

Packaging

C200/5/27 (4)

180

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

10/09/27
C210/9/27

Picklist Print

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Work Order ID: 60296



Parent Item: D2666-1



Parent Item Name: Saddle, LH Fwd Aft In 206

Start Date: 02/07/2010

Required Date: 29/07/2010

Start Qty: 4.00

Required Qty: 4.00

Comments: IPP: C□00.11.01□Removed P/O for Powder Coat - in house process□EC□
IPP Rev:D As per Rev D 07-03-19 JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
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D6101-001		Manufactured	No			100	Each	61.0000	1	4			
Saddle Billet													



Signature 10/09/20

Location

Loc Qty

Loc Code

MAT

40

46409

40

MAT40

21

46409

21

✓ 61385

8

4

DART AEROSPACE LTD	Work Order: 60296
Description: 206 Saddle, Inboard, Left side	Part Number: D2666-1
Inspection Dwg: D2666 Rev. D	Page 1 of 1

Inspect dimensions highlighted on inspection sheet drawing D2666 Rev. D and record below:

Dim	Min	Max	Go/No Go Gauge	Recorded Actual Dimensions				By	Date
				1	2	3	4		
A	0.100	0.140		0.122	0.120	0.120	0.120	118-120	Deep Mic
B	0.100	0.140		0.120	0.120	0.120	0.120	DTP-02	Mic
C	2.470	2.510		2.490	2.490	2.490	2.490	DTP-11	Vern
D	0.100	0.180		0.145	0.145	0.145	0.145		"
E	0.210	0.230	0.217	0.217	0.217	0.217	0.217	DTP-02	Mic
F	1.313	1.343		1.320	1.320	1.320	1.319	DTP-11	Vern
G	0.240	0.260		0.246	0.245	0.244	0.244		"
H	0.615	0.685		0.670	0.670	0.670	0.670		"
I	1.125	1.145		1.134	1.1345	1.135	1.135		Dial
J	0.990	1.010		1.004	1.004	1.004	1.004	DTP-11	Vern
K	0.235	0.240		0.237	0.237	0.237	0.237	DTP-02	Mic
L	0.510	0.515		0.510	0.510	0.510	0.510	DTP-11	Vern
M	0.100	0.120		0.120	0.120	0.120	0.120		N/A
N	1.565	1.585		1.5715	1.5725	1.578	1.578		Dial
O	5.990	6.010		6.002	6.002	6.002	6.002	DTP-11	Vern
P	1.245	1.255		1.250	1.250	1.250	1.250		"
Q	2.495	2.505		2.500	2.500	2.500	2.500		"
R	0.490	0.510		0.498	0.500	0.500	0.498		"
S	0.313	0.318		0.316	0.316	0.316	0.316		"
T	2.495	2.505		2.500	2.500	2.500	2.500		"
U	1.357	1.367		1.362	1.362	1.362	1.362		"
V	0.315	0.322		0.318	0.318	0.318	0.318		"
W	0.540	0.560		0.547	0.547	0.547	0.547		"
X	1.674	1.684		1.179	1.179	1.179	1.179		"
Y	0.257	0.262		0.259	0.259	0.259	0.259		"
Z	0.178	0.198		0.188	0.188	0.188	0.188		Rad Gage
AA									
AB									
AC									
AD									
AE									
AF									
Accept/Reject									

Measured by: DTP
Date: 10/09/20

Audited by: [Signature]
Date: 10/09/23

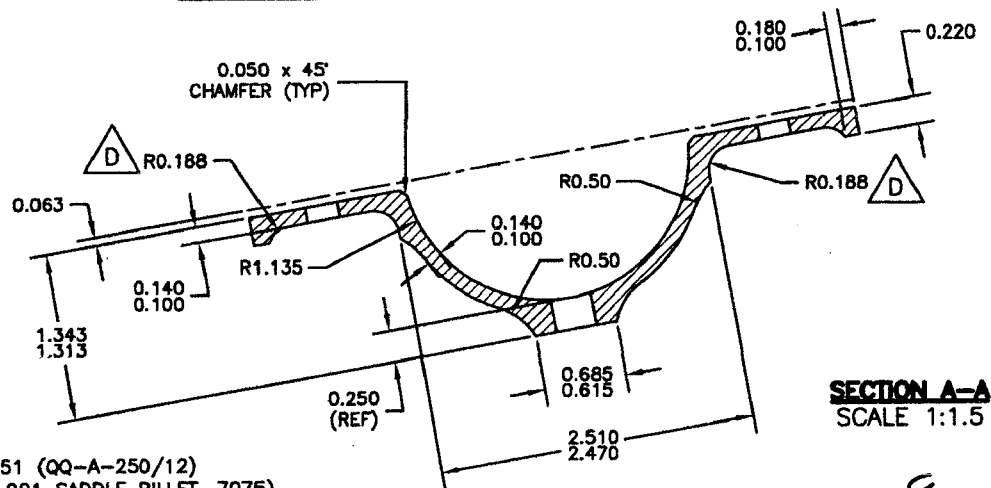
Rev	Date	Change	Revised by	Approved
A		New Issue	RF	
B	99.04.19	Incorporated DSI 9095, DSI 9102 & DSI 9122 Rev. A	RF	
C	99.11.10	Added Dim. R-T	RF	
D	02.12.12	Reformat; Added Dim. U-W & DT8683, DT8686 & DT8695 A/B	KJ/RF	
E	06.06.30	Dimension revised per drawing revision C	KJ/JLM	
F	06.09.19	Reference to DT8888 added to Dim N	KJ/EC	
G	07.03.21	Revised per drawing revision D	KJ/JLM	

DART

DESIGN #	DRAWN BY CB	DART AEROSPACE USA, INC. PORT HADLOCK, WA	
CHECKED PH	APPROVED H	DRAWING NO. D2666	REV. D SHEET 1 OF 1
DATE 06.11.08	TITLE SADDLE FWD INSIDE HIGH		SCALE 1:3
A	97.03.25	NEW ISSUE	
B	97.07.11	ANGLE AND NOTES ADDED	
C	06.05.26	INCORPORATE DEO 9122, 9102, 9095	
D	06.11.08	R0.188 WAS R0.30; Ø0.316 WAS Ø0.313	

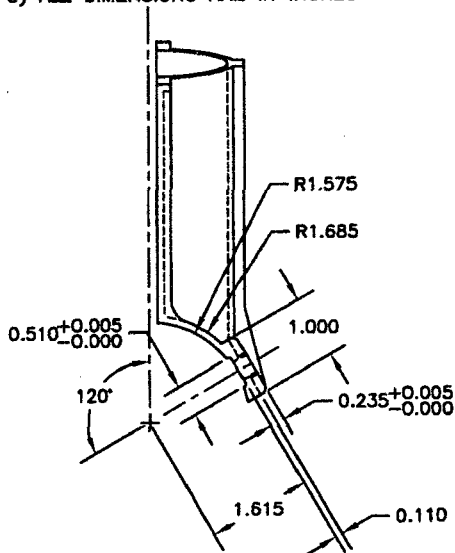
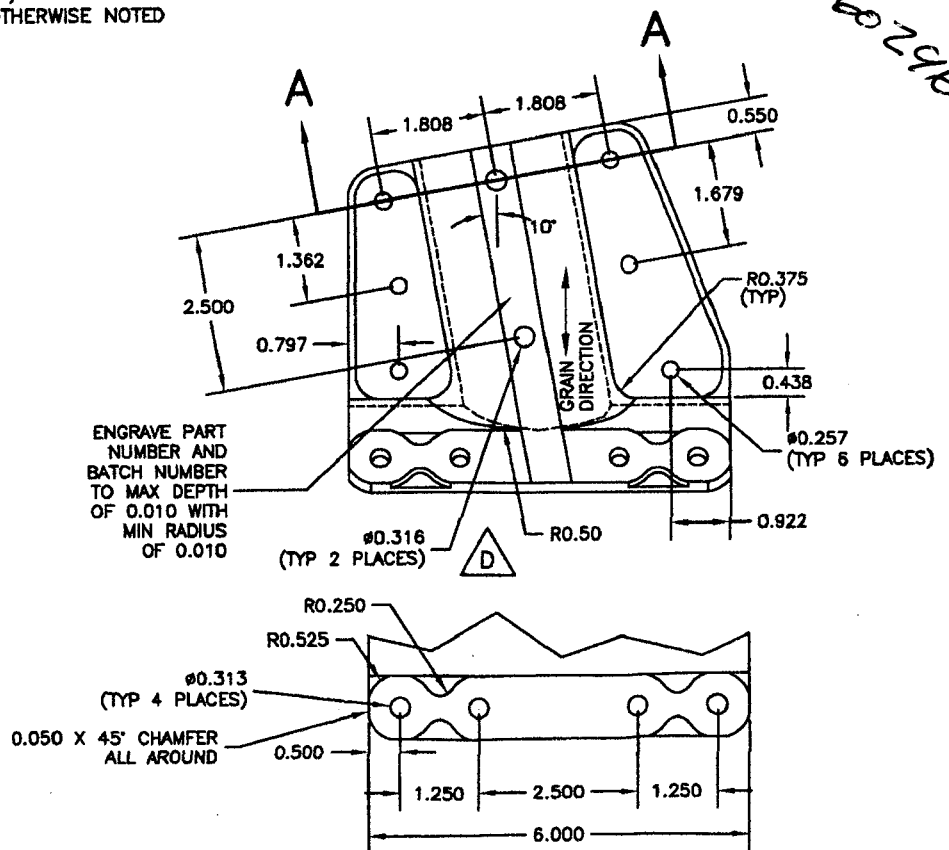
RELEASED

07.02.12



NOTES:

- 1) MATERIAL: ALUMINUM 7075-T7351 (QQ-A-250/12)
(MAKE FROM D6101-001 SADDLE BILLET, 7075)
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
POWDER COAT GLOSS WHITE (4.3.5.1) PER DART QSI 005 4.3
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) BREAK ALL SHARP EDGES 0.010 TO 0.020
- 5) D2666-1 SHOWN (D2666-2 IS OPPOSITE)
- 6) ALL DIMENSIONS ARE IN INCHES

**D2666-1 SADDLE FWD INSIDE HIGH**

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